

Date: Tuesday, 13/05/2008 11:08:52 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FORWARD CAP
 Job Number : 39242
 Estimate Number : 10501
 P.O. Number :
 This Issue : 13/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run : 37768
 Part Number : D2744
 Drawing Number : D2744 REV C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 30/05/2008 Qty: 40 Um: Each
 Written By :
 Checked & Approved By : JLD 08.5.13
 Comment : Est C 03.01.17 Reformat; Dwg revised KJ/RF
 Est Rev:D Now on Waterjet 06-06-16 JLM
 Est Rev:E As per Rev C 07-07-28 JLM Verified By:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S080 5052-H32 .080 Sheet



11.5



Comment: Qty.: 0.1914 sf(s)/Unit Total : 7.6566 sf(s)
 Material: 5052-H32 (QQ-A-250/8) or 6061-T6 (QQ-A-250/11) 0.080 thick.
 Use off-cuts
 M5052H32S.080) Batch 100742 1B 8-5-14

2.0 WATER JET FLOW WATER JET



28: 5.4



Comment: FLOW WATER JET
 1-Cut as per Dwg D2744
 Dwg Rev: C
 Prog Rev: C

1B 8-5-14

58

2-Deburr if necessary 1B 8-5-14

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



1B 8-5-14



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/05/14 (58)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: LG

BE 08/05/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/05/2008 11:08:52 AM
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Job Number: 39242

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/16 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

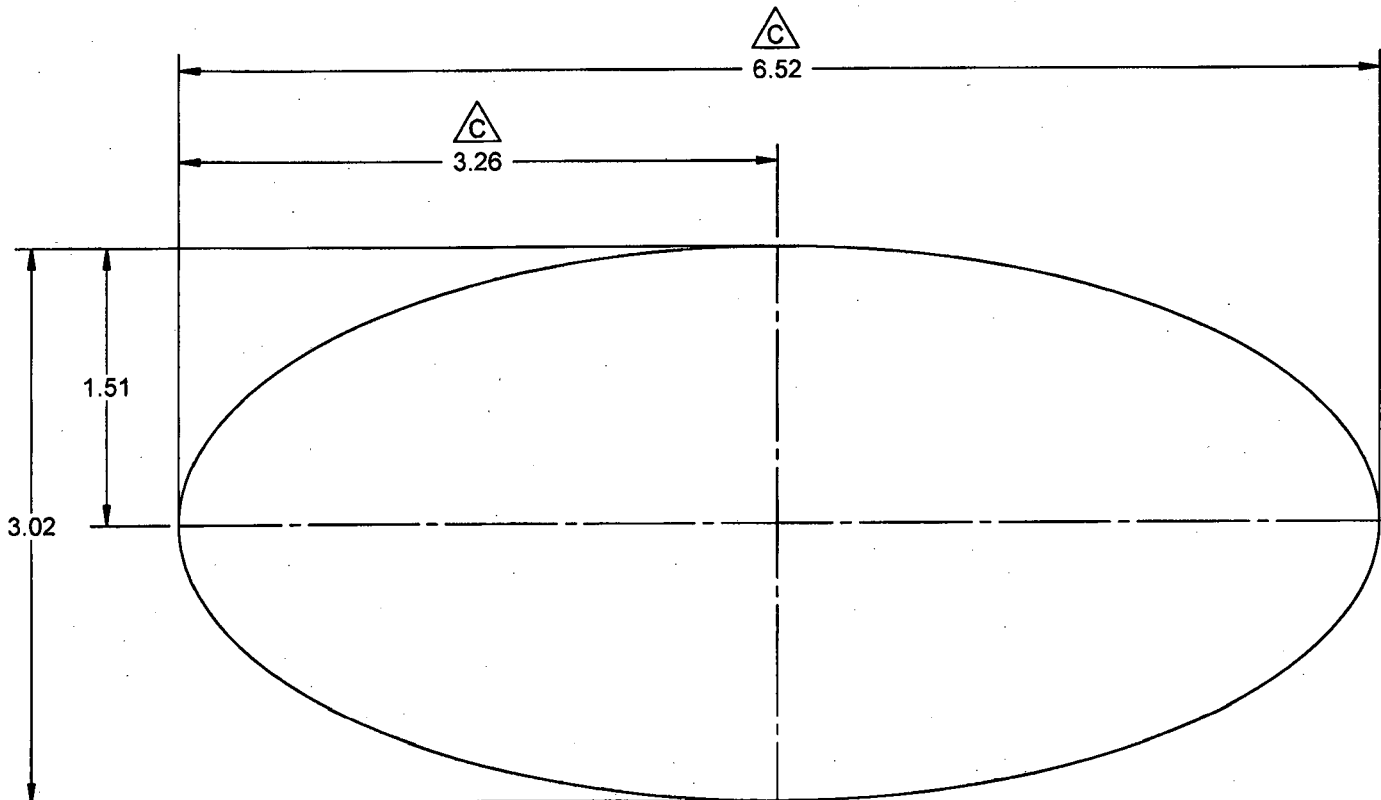
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D2744	REV. C SHEET 1 OF 1
DATE 06.10.05		TITLE CAP	SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	02.12.18	RE-DESIGN	
C	06.10.05	3.26 WAS 3.13; 6.52 WAS 6.27	

RELEASED
07-08-02



D2744 CAP

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6 SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.080)
OR ALUMINUM 5052-H32 SHEET 0.080 THICK PER QQ-A-250/8 OR AMS 4016
(REF DART SPEC M5052H32S.080)

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39242

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